

Date: Tuesday, 07/04/2009 10:19:26 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 46966	
Estimate Number : 12105	
P.O. Number :	Part Number : D32011
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D3201 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 46854	Material :
Written By :	Due Date : 20/04/2009 Qty: 30 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est Rev:A Removed from 9 Digit 06-01-25 JLM Est Rev:B Now on Waterjet 06-08-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2898 sf(s)/Unit Total : 8.6940 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040)
 Identify for D3201-1
 Batch: 111381 189-4-13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3201
 Dwg Rev: 8 189-4-13
 Prog Rev: 8
 2-Deburr if necessary 189-4-13

33

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

809104113 counter 733

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

1/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:19:26 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 46966

Part Number: D32011

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

09-04-14

33

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 09/04/14

33

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

76

9/4/14

Se

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



U 09.04.14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

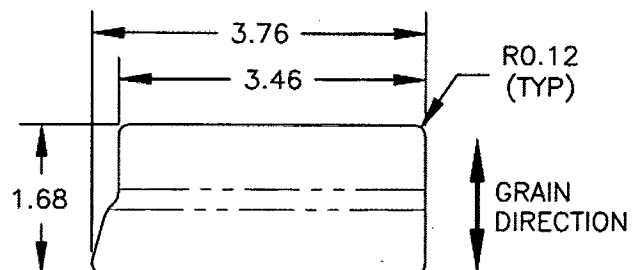
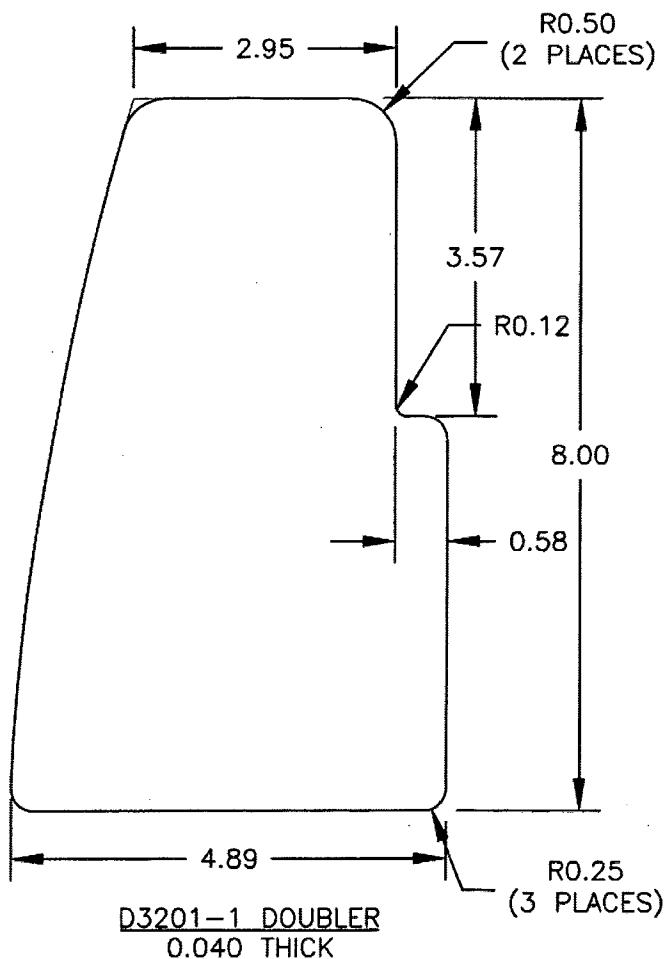
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

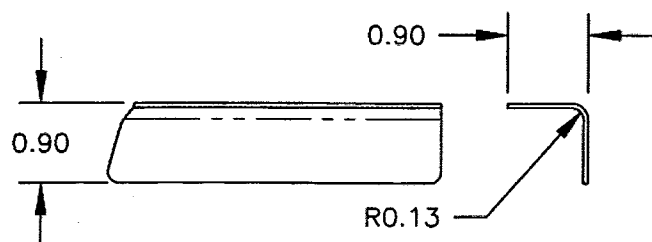
NOTE: Date & initial all entries

DART

DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3201 REV. B SHEET 1 OF 1
DATE	03.11.03	TITLE	DOUBLER	SCALE 1:2
A	03.08.07	NEW ISSUE		
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4		

RELEASED
03.11.14

D3201-3/-4 ANGLE
(FLAT PATTERN)



D3201-3 ANGLE (SHOWN)
D3201-4 ANGLE (BEND OPPOSITE)
0.050 THICK

D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
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